

Work Order ID 95698

January-17-13 1:37:50 PM

95698

Page 1

Item ID: D3065-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Step Spacer

Stop

NS2

Start Date: 1/16/13

Start Qty: 40.00

40

Cust Item ID:

Required Date: 2/08/13

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: ML5Date: 13-01-18

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								
100 *100* Waterjet	FLOW WATER JET	0.00							
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110 *110* QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
Quality Control	Memo	0.00							
120 *120* QC	QC8- Inspect parts - second check	0.00	<i>AS</i>						
Quality Control	Memo	0.00	<i>13-2-14</i>					<i>40</i>	<i>05</i>

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			Rework Scrap Use-as-is Work Order Update		Skid-tube Machining Thermoforming Large Fab		Crosstube Small Fab Finishing Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other	
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear					General						
					Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube	Bend BOM/Route Broken/Damaged Burr Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabelled Misread Offset Out of Calibration Out of Sequence Outside Dimensions	Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	Other	

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order ID 95698

95698

Page 3

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NS1

Revision ID:

Item Name: Step Spacer

Stop

NS2

Start Date: 1/16/13

Start Qty: 40.00

40

Cust Item ID:

Required Date: 2/08/13

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

160

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

42 13-2-8

170

170

QC

Quality Control

QC3- Inspect Part Finish

0.00

AS
5
13-2-11

40 Count

180

180

Packaging

Packaging

Identify as per dwg & Stock Location

GA

0.00

Memo

0.00

40x 13-2-11

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
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Supplier											
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Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions							
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other							
				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled							

Work Order ID 95698***95698***

January-17-13 1:37:50 PM

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Item ID: D3065-3

Accept

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Setup

Start

NS1

Revision ID:

Item Name: Step Spacer

Stop

NS2

Start Date: 1/16/13 Start Qty: 40.00

40

Cust Item ID:

Required Date: 2/08/13 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
Description

190

QC21- Final Inspection - Work Order Release

190

QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

13/2/13 40

MLJ 13-02-12

NCR: Yes / No

DQA: Date:

WORK ORDER NON-COMPLIANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data											
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Material											
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FAULT CATEGORY											
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions							
				Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge							
				Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other							

Picklist Print

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Page 1

Work Order ID: 95698

Parent Item: D3065-3

Start Date: 1/16/13

Required Date: 2/08/13

Parent Item Name: Step Spacer

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: C02.11.01 Incorporated D3066-1 IPPKJ/RF
IPP Rev:D Now on Water Jet 06-04-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	247.2023	0.2178	<u>9.170528</u>			13-02-02

Location	Loc Qty	Loc Code
MAT022	247.2023252	
120605	65.8254832	
121197	64.996842	
122136	31.78	
123217	84.6	

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____ NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
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DART AEROSPACE LTD	Work Order:	95698
Description: Step Spacer	Part Number:	D3065-3
Inspection Dwg: D3065	Rev: B	Page 1 of 1

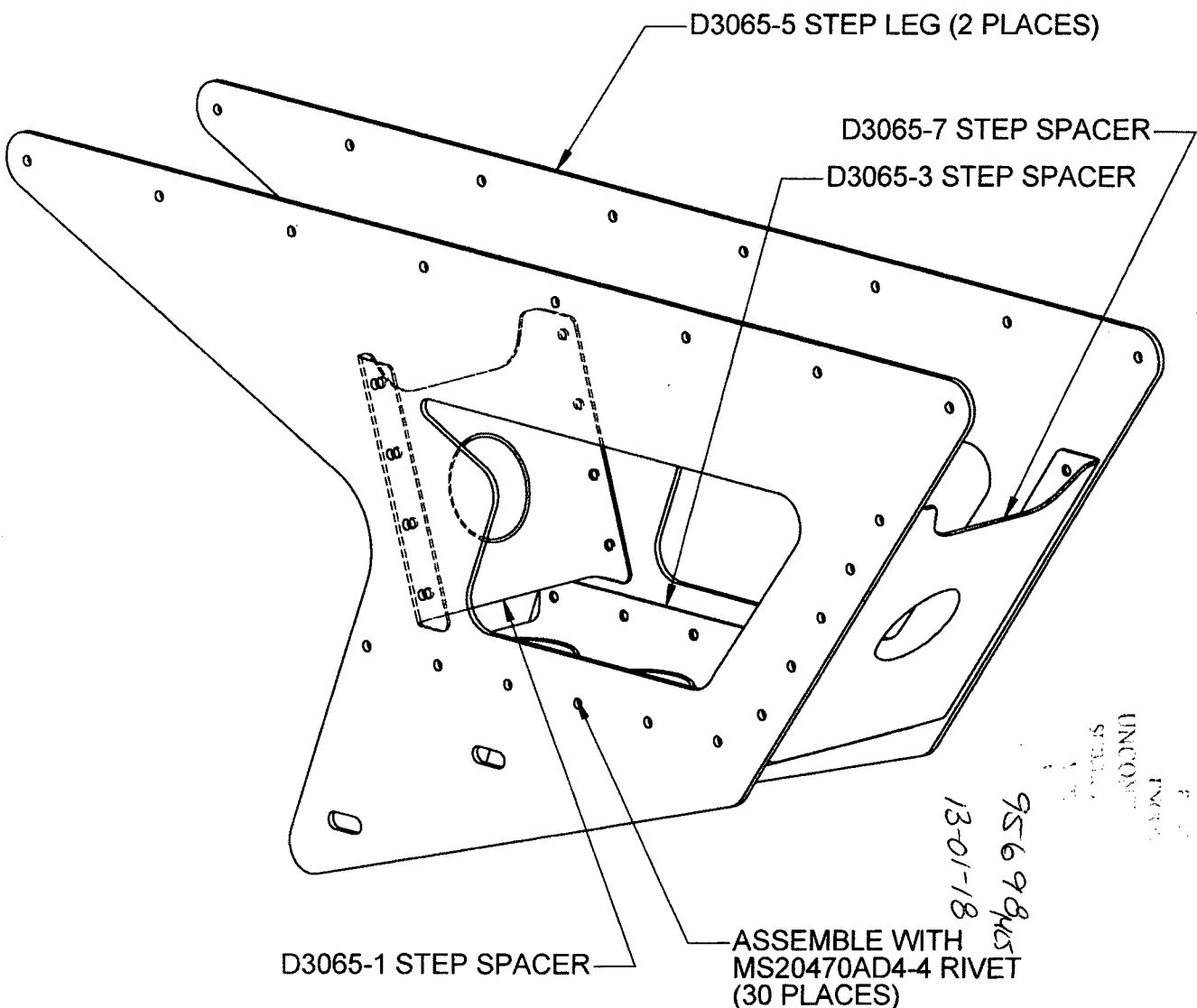
FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<i>✓</i>	Audited by:	<i>✓</i>	Preliminary Approval:	
Date:	13.02.02	Date:	13.2.4	Date:	

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3065-041	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	
D	07.09.06	0.040 dimension added	KJ/JLM	
E	12.10.10	Ø0.129 was Ø0.128	KJ	 

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B	SHEET 1 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY			SCALE 1:2
			A 02.09.11	NEW ISSUE
			B 06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5

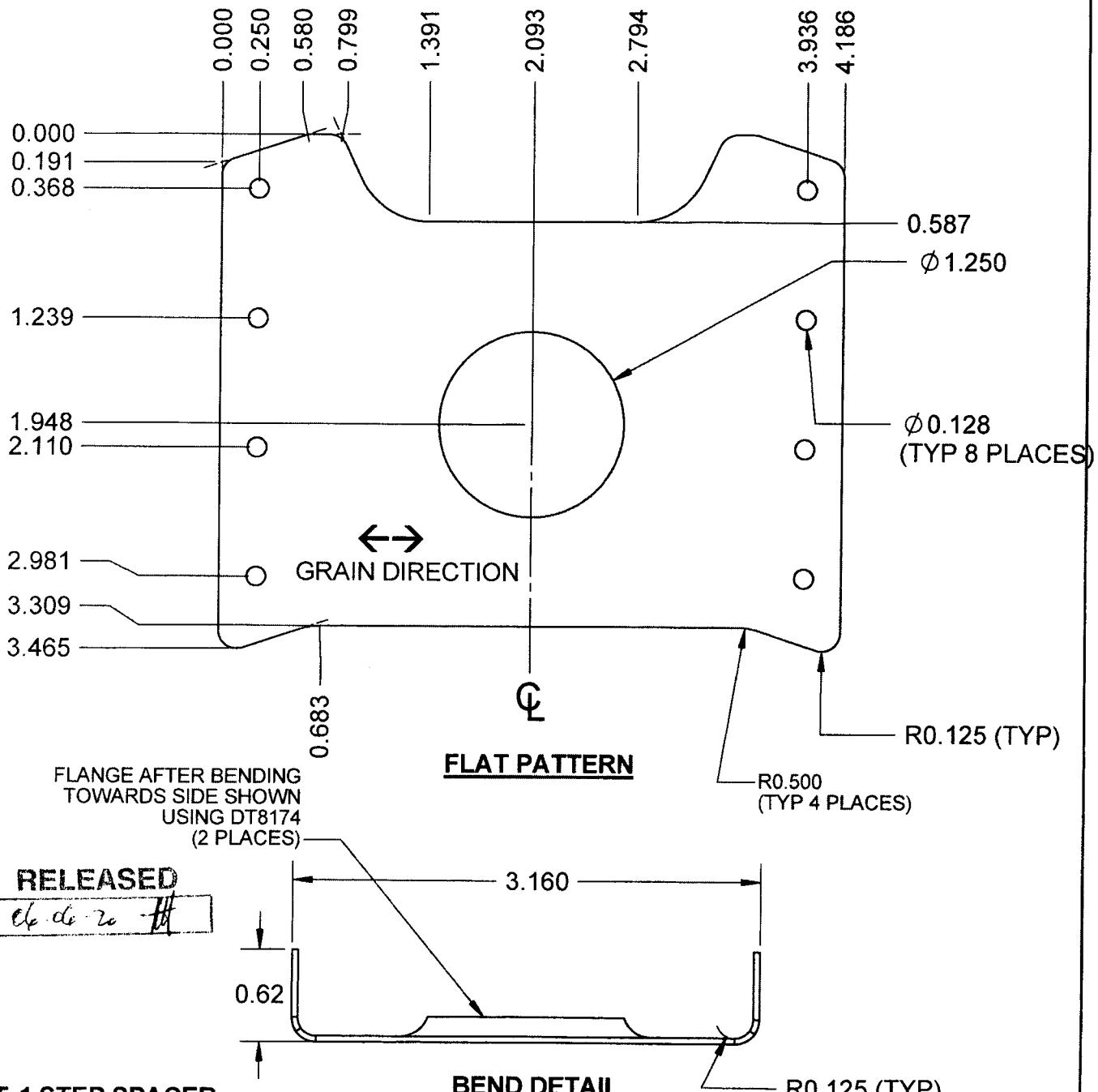
RELEASED*06.06.20 [Signature]***D3065-041 STEP LEG ASSEMBLY**

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DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

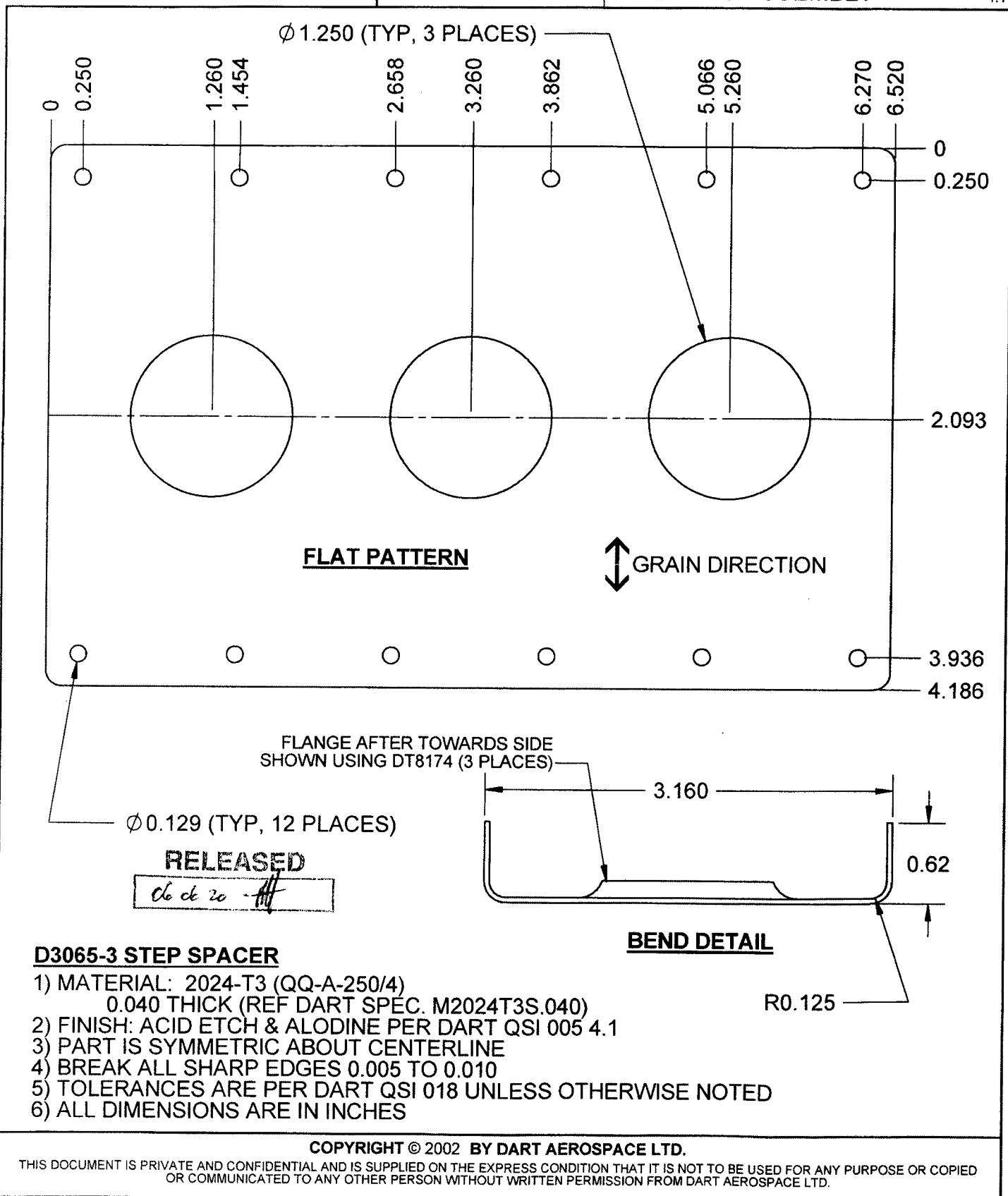
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06/05/02

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B	SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1	

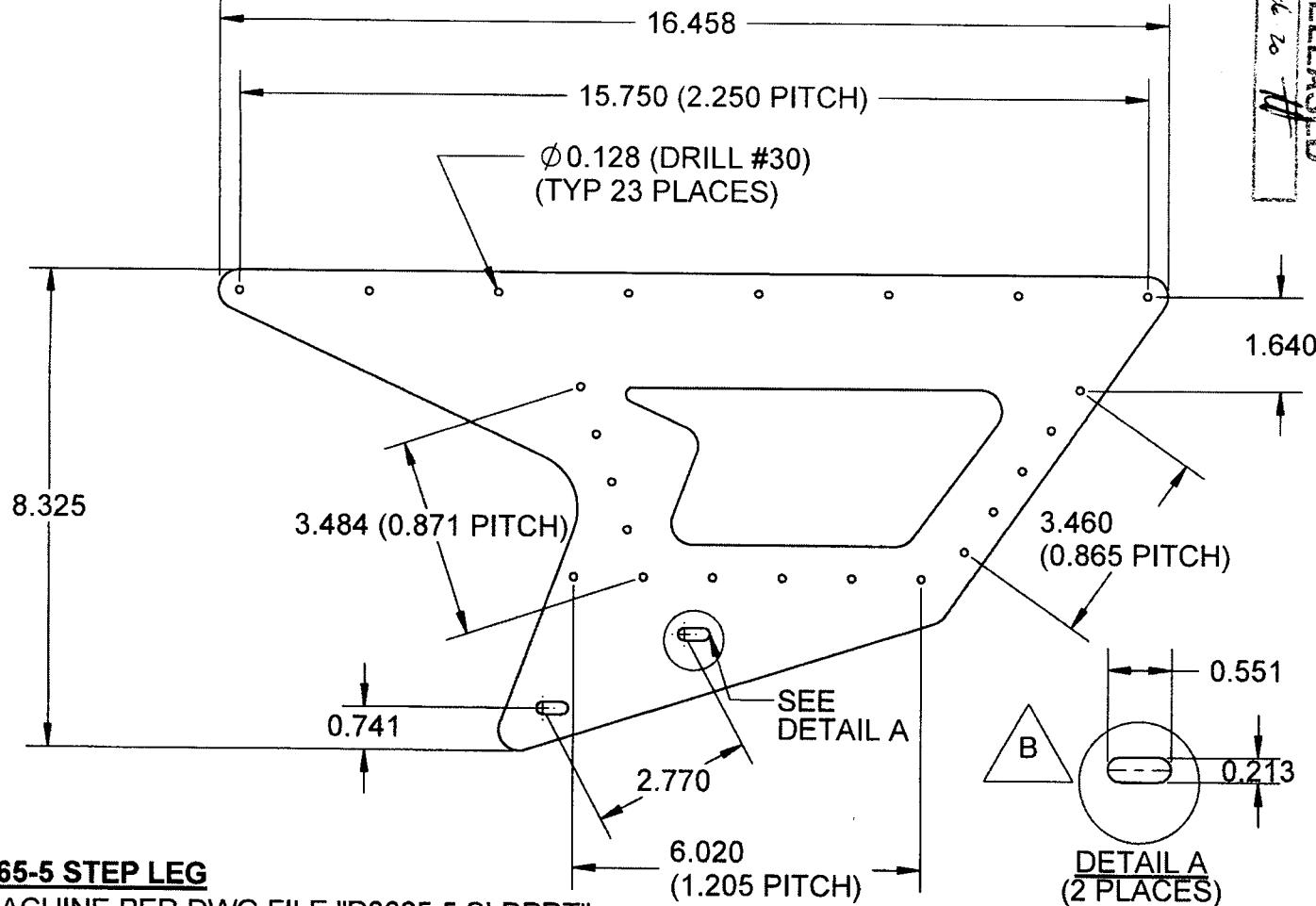


G5698

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
10	C.B.	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH	W	D3065
DATE	06.05.23	TITLE
		STEP LEG ASSEMBLY
		REV. B
		SHEET 4 OF 5
		SCALE
		1:3

RELEASED
06.06.20
H



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
PH	MM	D3065	REV. B
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY
		SCALE	1:1

